

**AMENDMENT TO THE CLAIMS**

Claims 1-7. (Canceled)

Claim 8. (*New*) A method for shaping a portion of a sheet metal lid for a beverage can, the lid comprising a panel having an openable area defined by a score line in said panel, and a mounting place for attaching a tab for breaking in said openable area, said method comprising:

- (i) forming at least one projection in said panel at least twice by
  - (a) shaping a pre-form of the at least one projection, from a portion of the panel, the pre-form placed at a distance from and opposite said mounting place for being suitably positioned to cooperate with an attaching portion of the tab when attached to said mounting place;
  - (b) re-forming at least a front portion of said pre-form to increase an angle of inclination of this front portion with respect to a remainder of the panel, to give the projection an asymmetrical cross-section and, during said re-forming, a top portion of the pre-form is flattened and stiffened;
- (ii) during said shaping and during said re-forming, no score line is created in said panel.

Claim 9. (*New*) A method according to claim 8, further comprising:

introducing or inserting a score line into said panel after said shaping the pre-form of the at least one projection.

Claim 10. (*New*) A method according to claim 8, wherein:

said re-forming comprises an embossing for flattening and stiffening the top portion of said projection.

Claim 11. (*New*) A method according to claim 8, wherein:

said stiffening provides a reduction of a sheet metal thickness of said pre-form.

Claim 12. (*New*) A method according to claim 8, wherein:

said score line is formed into said panel after said re-forming of said pre-form.

Claim 13. (*New*) A method according to claim 8, wherein:

said score line is formed into said panel after shaping said pre-form from said portion of the panel, and prior to said re-forming of said pre-form.

Claim 14. (*New*) A method according to claim 8, wherein:

said re-forming and said shaping are done at one forming station.

Claim 15. (*New*) A method for shaping a portion of a sheet metal lid for a beverage can, the lid comprising a panel having an openable area defined by a score line in said panel, and a mounting place for attaching a tab for breaking in said openable area, said method comprising forming at least one projection in said panel by

- (a) shaping a pre-form of the at least one projection from a portion of the panel, the pre-form placed at a distance from and opposite said mounting place for being suitably positioned to cooperate with an attaching portion of the tab when attached to said mounting place;
- (b) re-forming at least a front portion of said pre-form to increase an angle of inclination of said front portion with respect to a remainder of the panel, to give the projection an asymmetrical cross-section and, during said re-forming, a top portion of the pre-form is flattened and stiffened.